

DART AEROSPACE LTD	Work Order:	21984
Description: Bracket ass'y	Part Number:	D2803-043041
Dwg: D2803 rev.A I	Qty:	1

RF 03.03.07

Step	Location	Procedure	By	Date	Qty																
1	EXPEDITING	Issue W/O	CP	04.11.30	1																
2	STORES	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2803-1</td><td>Bracket</td><td>B21977</td></tr><tr><td>1</td><td>D2805-3 D2805-1</td><td>Stop</td><td>B14243</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B17194</td></tr></table>	Qty	Part Number	Description	Batch	1	D2803-1	Bracket	B21977	1	D2805-3 D2805-1	Stop	B14243	1	D2809	Bushing	B17194	CP	04.11.30	1
Qty	Part Number	Description	Batch																		
1	D2803-1	Bracket	B21977																		
1	D2805-3 D2805-1	Stop	B14243																		
1	D2809	Bushing	B17194																		
3	METAL	Press D2805-3 into arm as per Dwg D2803 D2805-1 CP 04.11.30	CP	04.11.30	1																
4	QC	Inspect Level 5	CP	04.11.30	1																
5	FINISHING	Powder coat white (4.3.5.1) per QSI 005	MM	04.12.01	1																
6	QC	Inspect Level 3	CP	04.12.01	1																
3	METAL	Press D2809 into arm as per Dwg D2803	CP	04.11.30	1																
7	STORES	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>21</td><td>AN3-16A</td><td>Bolt</td><td>M14820</td></tr><tr><td>22</td><td>AN960JD10</td><td>Washer</td><td>M15102</td></tr><tr><td>21</td><td>MS21042L3</td><td>Nut</td><td>M15066</td></tr></table>	Qty	Part Number	Description	Batch	21	AN3-16A	Bolt	M14820	22	AN960JD10	Washer	M15102	21	MS21042L3	Nut	M15066	CP	04.11.30	1
Qty	Part Number	Description	Batch																		
21	AN3-16A	Bolt	M14820																		
22	AN960JD10	Washer	M15102																		
21	MS21042L3	Nut	M15066																		
8	METAL	Assemble as per DWG D2803	CP	04.11.30	1																
9	QC	Inspect Level 5	CP	04.12.01	1																
10	STORES	Identify and stock	CP	04.12.01	1																
11	EXPEDITING	Close W/O Cost / part: 79.11 545 04/12/02 (1)	CP	04.12.03	1																

Rev	Date	Change	Revised By	Approved
A	01.04.06	New Issue	EC	
B	01.04.26	Re format	EC	EC

Resume Steps

RELEASED

01.04.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

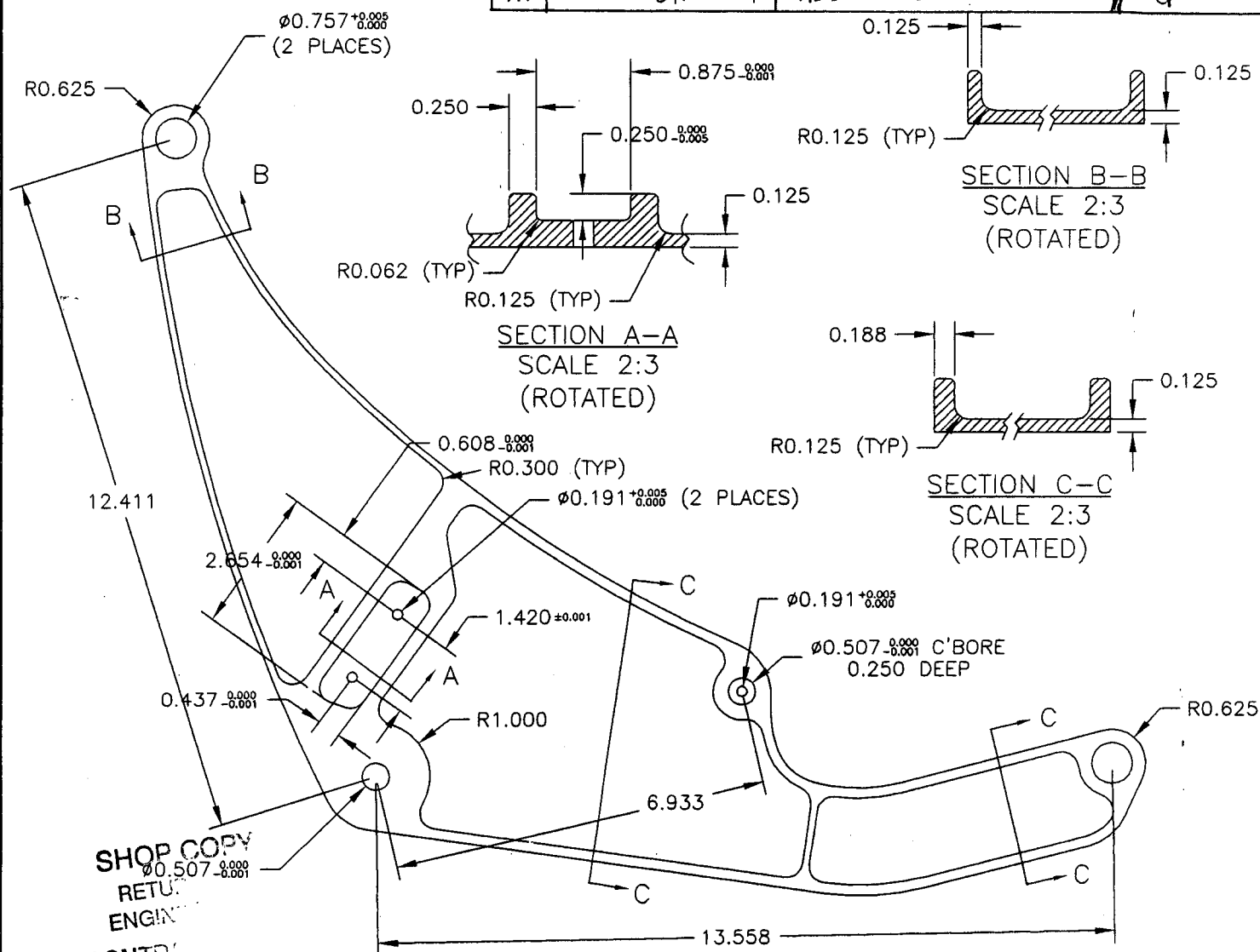
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. A SHEET 1 OF 2
DATE 00.11.07		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
A1	01.03.14	ADD D2803-043/-044 <i>CP</i>	



UNCONTR'
SUBJECT TO
WITHOUT

WORK OR
NO. 21984

D2803-1 (SHOWN)
D2803-2 (OPPOSITE)

RELEASED
00-11-13

MACHINE PER DRAWING FILE "D2803-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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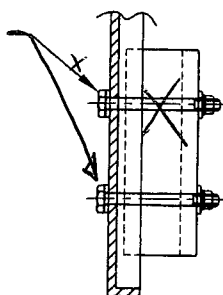
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2803	REV. A SHEET 2 OF 2
DATE 00.11.07	TITLE STA 84 BRACKET		SCALE 1:3

RELEASED
00.11.13

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

(1 PLACE)

CP 04.11.30



USE D2803-1 FOR D2803-041 & -043
USE D2803-2 FOR D2803-042 & -044
SECTION D-D
SCALE 1:3
(ROTATED)

USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT

SHOP COPY
RET
ENC

UNCONT
SUBJECT
WITHOL

WORK C

NO. 21984

D2803-041 ASSEMBLY (SHOWN) → D2803-043 SIMILAR
D2803-042 ASSEMBLY (OPPOSITE) → D2803-044 SIMILAR

FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY
SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX
(4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 30, 2004
12:24 pm

Work Order No	: 0021984	Department Code:	
Project Name	: D2803-043	Burden Flags	: NNNNNNNN
Project For	: WK449	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2803-043	Invoice Number	:
Description	: STA 84 Bracket Ass'y LH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 1	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-30-04		
Est Finish Date	: 11-30-04	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00